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D4634-141
Job Sheet 167074



Part No: D4634-141

Job Qty: 1 ea

Part Name: Fwd, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/23/17

Job Tracking No:

Due Date: 11/24/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/23/17	0.00	0.00	Start up container	
100	HandThermo	1 pcs		11/23/17	0.00	1.65	HandFinish4	
110	Small Fab	1 pcs		11/24/17	0.00	1.47	Small Fab	
120	QC	1 pcs		11/24/17	0.00	0.00	QC5	
130	Packaging	1 pcs		11/24/17	0.00	0.00	Packaging3	
140	QC21-SA	1 Ea		11/24/17	0.00	0.00	QC21	

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4634-141 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: 138016 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8) Batch # 138649 Expiry Date 18/01/29 3- Apply labels as per Dwg. and seal with 3M

3950 edge sealer(see note 9) Batch: 135435

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D4634-1 <u>164268</u>	1 ✓	3	0	0
	D4636-5 ST107 - <u>164519</u>	1 ✓	43	0	0
	D4647-5 MF003 <u>129252</u>	1 ✓	2	0	0
	D4664-5 MF003 - <u>164066</u>	6 ✓	39	0	0
	D4712-1 MF003 <u>164607</u>	1 ✓	4	0	0
	D4732-15 - <u>157453</u>	1 ✓	2	0	0
	D4732-19 - <u>123209</u>	1 ✓	1	0	0
	D5021-1 - <u>165003</u>	1 ✓	2	0	0
	MPNY-750S-9-C - <u>130423</u>	1 ✓	570	0	0
	MS20426AD3-4 - <u>134394</u>	4 ✓	5,055	0	0
	MS20426AD4-6 <u>136537</u>	2 ✓	2,797	0	0
	MS21059L08 - <u>136554</u>	2 ✓	62	0	0

CONTAINER NOT ACTIVE

ST312

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
	Rework ☐ Scrap ☐ Use-as-is ☐ napproved ☐	Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐
	QTY Effective :				MRB (QS1042) Approval
	Disposition				Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
FAULT CATEGORY					
ntric e/Wave oe	☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence		
Misidentified ☐ Manufacturing Process ☐ OTHER : _____					

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DART
 AEROSPACE
S004464


Fwd, Center Ceiling Replacement Panel Assembly

PART NO: D4634 - 141
Revision: 1
Operation: Start up Operation
Quantity: 1
Change No:

 Mfg Date: 10/31/17
 Job No: 167074